

Date: Wednesday, 11/22/2006 1:39:01 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR PROCTOR FWD LH
Job Number : 29641	
Estimate Number : 11227	
P.O. Number : N/A	Part Number : D32811
This Issue : 11/22/2006 S.O. No. : N/A	Drawing Number : D3281 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 29424	Material : N/A
Written By : <i>[Signature]</i>	Due Date : 1/20/2007 Qty: 10 Um: Each
Checked & Approved By : <i>[Signature]</i> 06/11/22	
Comment : Est Rev. 04.07.01 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0

PG

PURCHASING

**Comment:** PURCHASING

Issue P/O: 2546

C20611122

(10)

Description: Floor Protector Fwd, LH

Possible Supplier: Delastek

Certificate of Conformity is required

2.0

D32811P

Floor Protector, Fwd LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Floor Protector Fwd, LH

3.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

4.0

QC6

DIMENSIONAL CHECK

**Comment:** DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins.

5.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: FD Date: 07/01/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/22/2006 1:39:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROCTOR FWD LH

Job Number: 29641

Part Number: D32811

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



10

Comment: FINAL INSPECTION/W/O RELEASE

FD07/11/25

Job Completion



U 07-11-25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

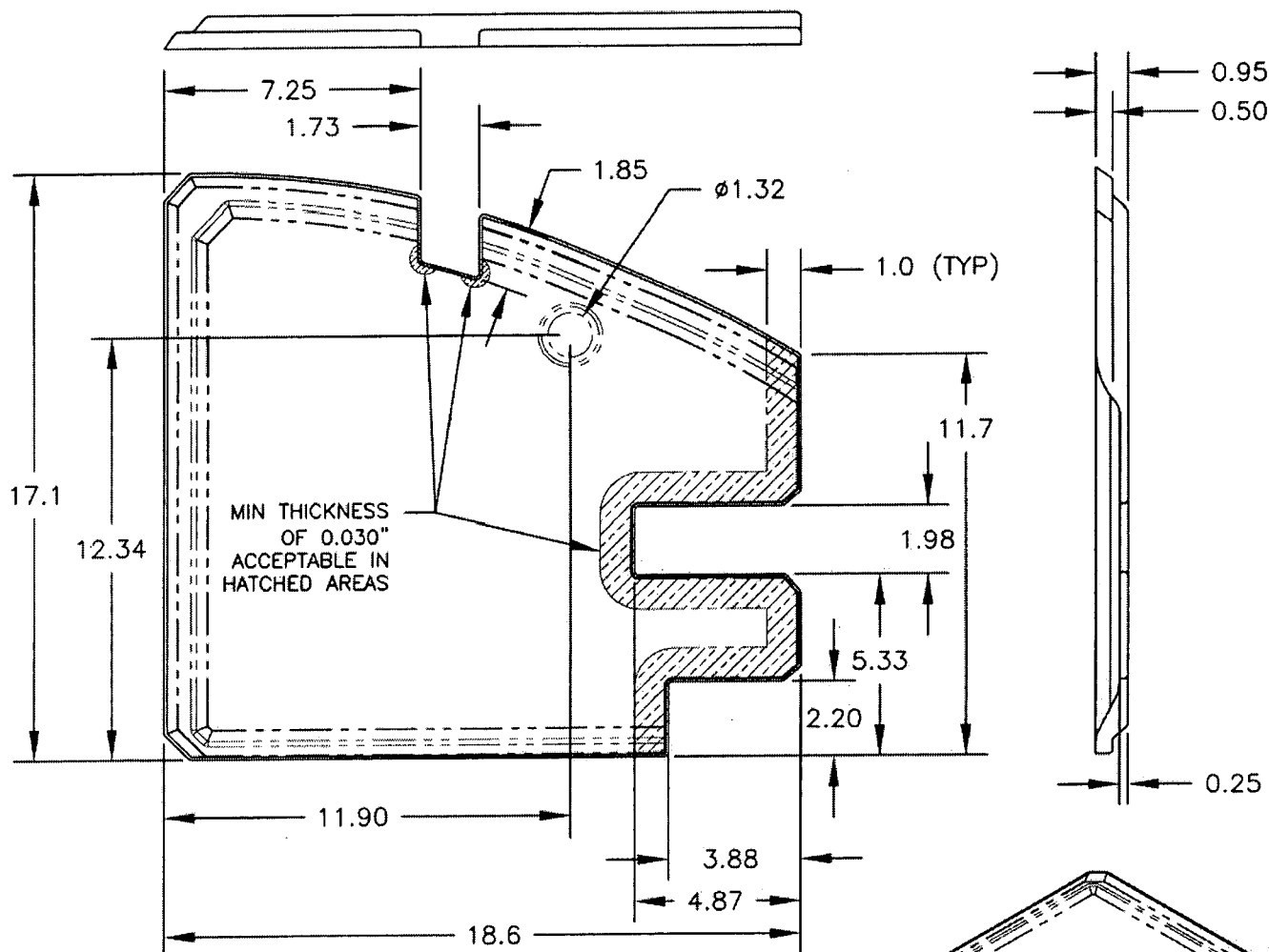
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

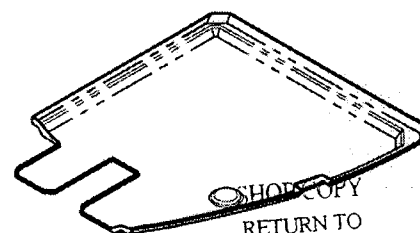
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3281	REV. B SHEET 1 OF 3
DATE 05.11.25	TITLE FLOOR PROTECTOR		SCALE 1:5
A	04.05.03	NEW ISSUE	
B	05.11.25	NOW LEXAN; DIMS AS MANUFACTURED	



RELEASED
05.12.01



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WITHOUT NOTICE
WORK ORDER
NO. 29641

D3281-1 FLOOR PROTECTOR, FWD LH

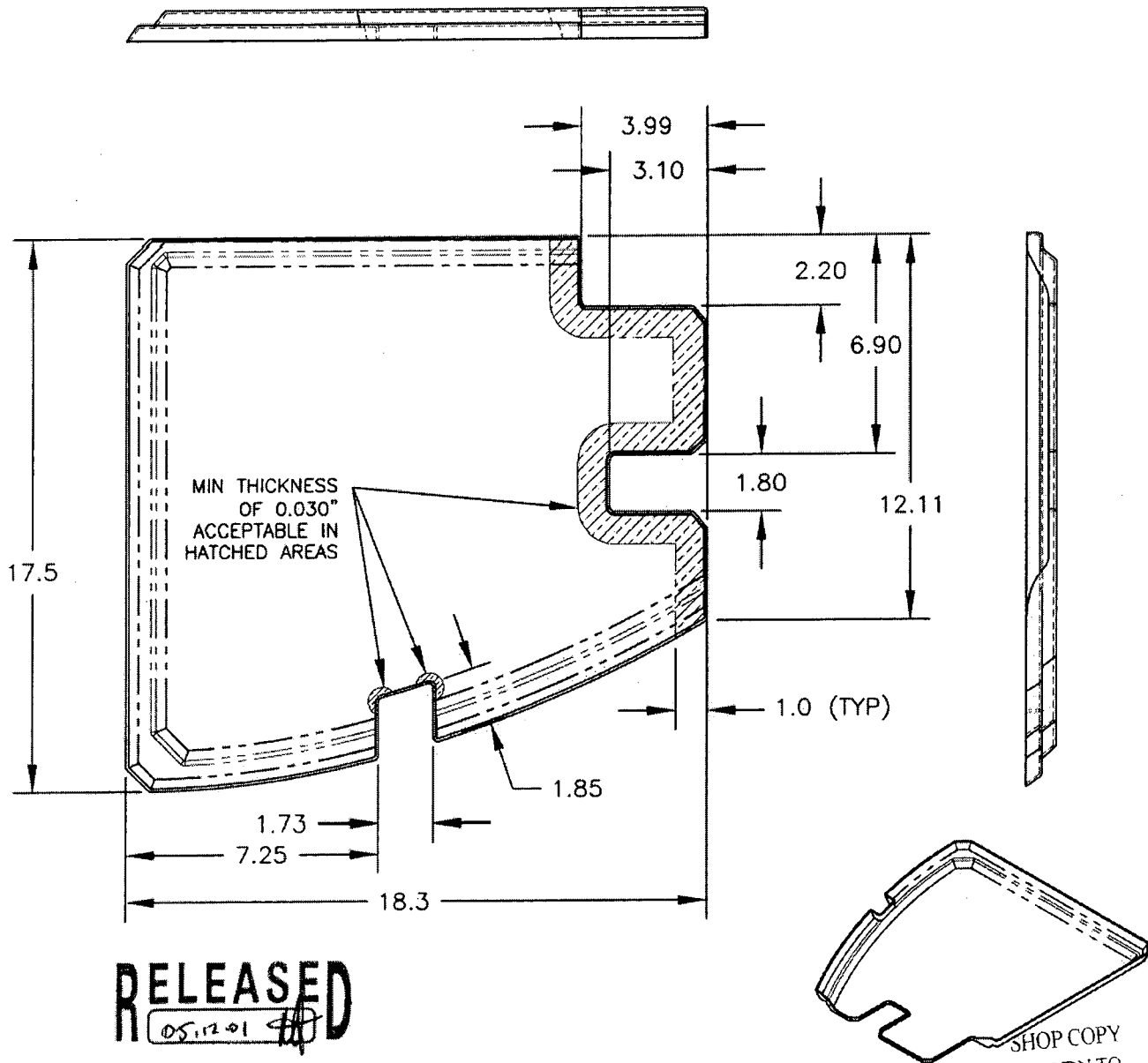
- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 2 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5

**D3281-2 FLOOR PROTECTOR, FWD RH**

- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

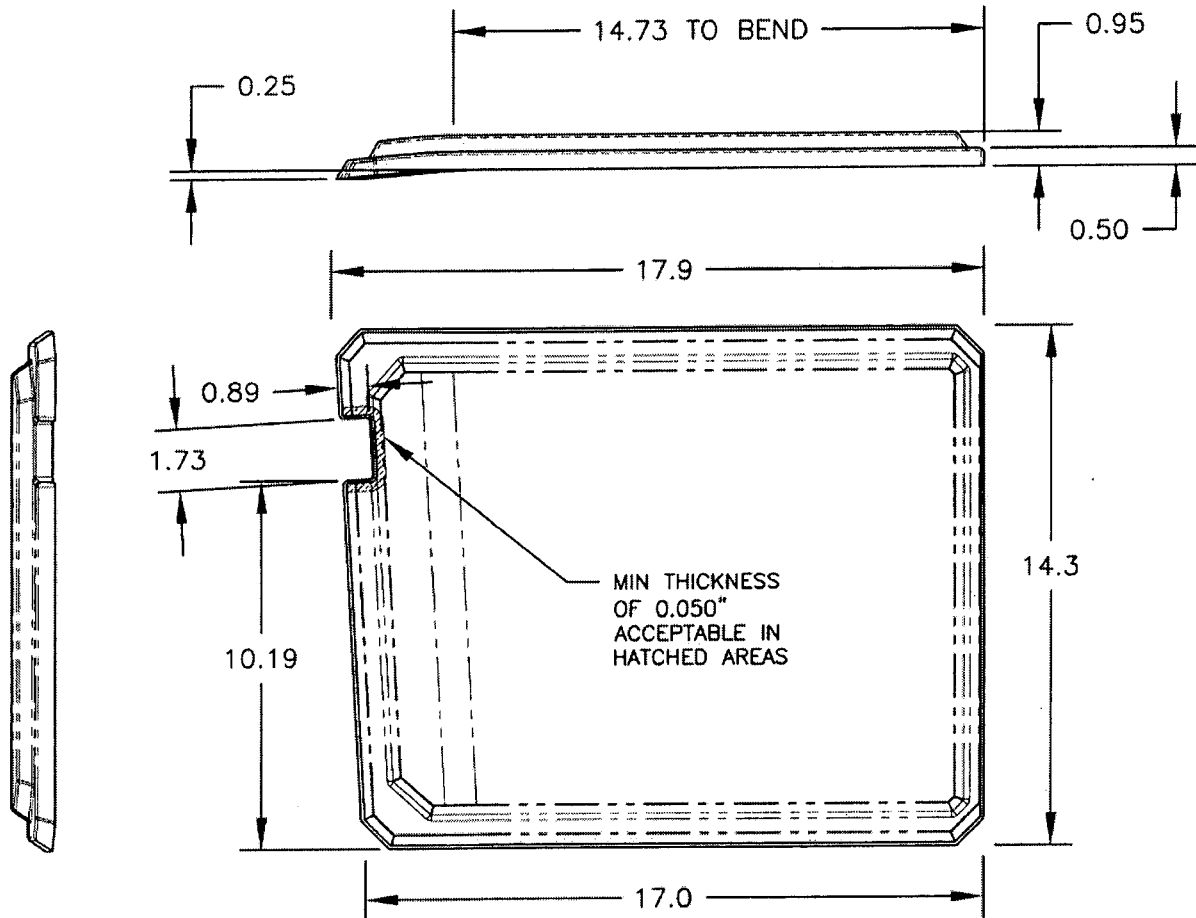
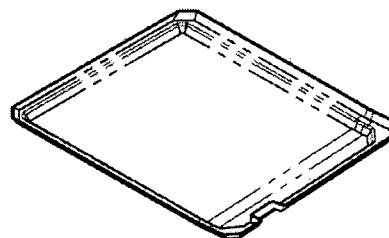
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 3 OF 3
DATE 05.11.25	TITLE FLOOR PROTECTOR		SCALE 1:5

**RELEASED**
05.12.01. *[Signature]*

D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)
D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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Date: Jeudi, 2006-11-16 15:00:51
Utilisateur: Sylvie Hamel

Feuille de Procédé

Client : DART Dart Aerospace Ltd.
Numéro Job : 40353
Numéro Soumission : 2383
Numéro B.A. :
Cette fois : 2006-11-16 No. B.V. :
Prsht Rev. : NC
Prem. fois : - - Type :
Job précédente : 36892

Nom Dessin : FLOOR PROTECTOR
Numéro Article : DKC134-0044
Numéro Dessin : D3281
Projet Numéro : DKC134
Révision dessin : B
Matériel : F6006
Date Dûe : 2006-12-08

Qté: 25 U/M: UNITE

Écrit par :
Vérifié & Approuvé par :
Commentaires : N° de pièce: D3281-1



Process Sheet Rév.: 00 Création du premier

Produit additionnel

Numéro Job:

# Séq.:	Machine ou Opération:	Description :
1.0	APL0016	Lex

Commentair Qty.: 0.167 UNITE(s)/Unit Total : 0.835
Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

APL0016

Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.
Bon achat: 5913

3-5913-1

N° de Lot: _____

2.0	SÉCHAGE/ ANEAL	SÉCHAGE / ANEALING
-----	----------------	--------------------



Commentair Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.1667Hrs
SÉCHAGE DU MATÉRIEL

Sécher le matériel dans le four à 250° F pendant 6 heures.
Inscrire sur la carte de température le numéro de Job du matériel au séchage.
de cuisson: 3483

3.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 15.0000Hrs
TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.

Quantité: 25 Date: 10-1-07 Sceau:

Quantité: _____ Date: _____ Sceau: _____

Date: Jeudi, 2006-11-16 15:00:52

Opérateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: FLOOR PROTECTOR

Numéro Job: 40353

Numéro Article: DKC134-0044

Numéro Job:



Séq.: Machine ou Opération: Description:

4.0

THERMOFORMAGE2

THERMOFORMAGE DES PIÈCE DART



Commentaire Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 0.8333Hrs
THERMOFORMAGE DES PIECES

Faire le thermoformage du " Floor Protector " N° D3281-1 à l'aide du moule N° D3281-1T1 sur le
thermoformeur 4' x 8'.

Autocontrôle du lot de pièce thermoformées.

Quantité: 25 Date: 10-1-07 Sceau: _____



100000

Quantité: _____ Date: _____ Sceau: _____

5.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.8333Hrs
TRIMAGE PLASTIQUE DART

Faire le trimage du " Floor Protector " N° D3281-1 à l'aide du gabarit de trimage N° D3281-1T2.

Faire l'ébavurage des pièces.

Autocontrôle du lot de pièce trimées.

Quantité: 25 Date: 12-01-07 Sceau: _____



Quantité: _____ Date: _____ Sceau: _____

6.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.4167Hrs
INSPECTION PIÈCE DART

Faire l'inspection finale des pièces selon le dessin.

Quantité: 25 Date: 18-01-07 Sceau: _____



7.0

IDENTIFICATION4

IDENTIFICATION PIÈCES DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.4167Hrs
IDENTIFICATION PIÈCES DART

Faire l'identification des pièces à l'aide des informations suivantes:

ate: Jeudi, 2006-11-16 15:00:52
illepteur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40353

Nom Dessin: FLOOR PROTECTOR
Numéro Article: DKC134-0044

Numéro Job:



Séq.: Machine ou Opération: Description :

N° de pièce: D3281-1

N° de Job: 40353

Date de fabrication: 15-1-07

Sceau d'inspection.

Quantité: 25 Date: 15-1-07 Sceau: EB

Quantité: _____ Date: _____ Sceau: _____

8.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.4167Hrs
EMBALLAGE ET ENTREPOSAGE

Emballer les pièces individuellement dans un sac en plastique et ensuite mettre dans une boîte en carton identifiée comme suit:

N° de pièce: D3281-1

Date de fabrication: _____

N° de job: _____

Quantité: 25 Date: 18/1/07 Sceau: 11

Quantité: _____ Date: _____ Sceau: _____





DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	11498
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #
19/01/07	23/11/06	5021	C. Lavoie	PO00002546		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description		
10	0	10	DKC134-0044	Floor Protect Part 1 N° D3281-1 (F6006) B29641 Selon dessin D3281 Rev.: B Job: 40353 <i>11/07/07/23</i>		
10	0	10	DKC134-0045	Floor Protect Part 2 N° D3281-2 (F6006) B29642 Selon dessin D3281 Rev.: B Job: 38794 (x2) Job: 40355 (x8)		
10	0	10	DKC134-0046	Floor Protect Part 3 N° D3281-3 (F6006) B29643 Selon dessin D3281 Rev.: B Job: 40356		
10	0	10	DKC134-0047	Floor Protect Part 4 N° D3281-4 (F6006) B29644 Selon dessin D3281 Rev.: B Job: 34176 (x1) Job: 40357 (x9)		

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

[Signature] 12/16/07
Quality department AQ-357